

Work Order ID 68268

Monday, April 11, 2011 10:37:50 AM



Page 1

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *UML*

Date: 11-04-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr								
D3195	Rev A								

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

*11/04/14**4* *Ø*

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-
3□2-Deburr*B.A 11/04/15**4* *Ø*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

*B.A 11/04/15**4* *Ø*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC8- Inspect parts - second check

0.00

Apr 11/15

4 0

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

4 0 40 40 40

HandFinish

Hand Finishing

Memo

0.00

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

W 11 04 19 (4)

Powdercoat

Powder Coating

Memo

0.00

START TIME: 01:00 OVEN TEMPERATURE:
030 FINISH TIME: 320°

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Page 3

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Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

4 4 160 v6/19

QC

Quality Control

Memo

0.00

170



Small Fab

0.00

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface□2-Bond D3195-7 into D3195-13as per Dwg
D3195□A/RContact Cement ✓

(4x) 3/4 11/04/19

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

SB 11/04/19

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Item Name: Bracket Assembly

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Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 246ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11/4/19SF

(4)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

11/4/19JJ

Memo

0.00

MF

11-04-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Mondgy, April 11, 2011 10:37:56 AM

Page 1

Work Order ID: 68268



Parent Item: D3195-043



Parent Item Name: Bracket Assembly

Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7 		Manufactured	No			100	Each	7.0000	1	4		SB 1104119	(4)

Pad

Location	Loc Qty	Loc Code
GA	7	
51569	3	
64534	4	

M6061T6B1.500X01.25
0



6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT004	15.47	
107461	0.9	
110936	14.57	

1.263 1104119

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68268
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B.A	Audited by:	CMR	Prototype Approval:	N/A
Date:	11/04/15	Date:	11/04/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	<i>[Signature]</i>
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	<i>[Signature]</i>

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NOTE: Date & initial all entries

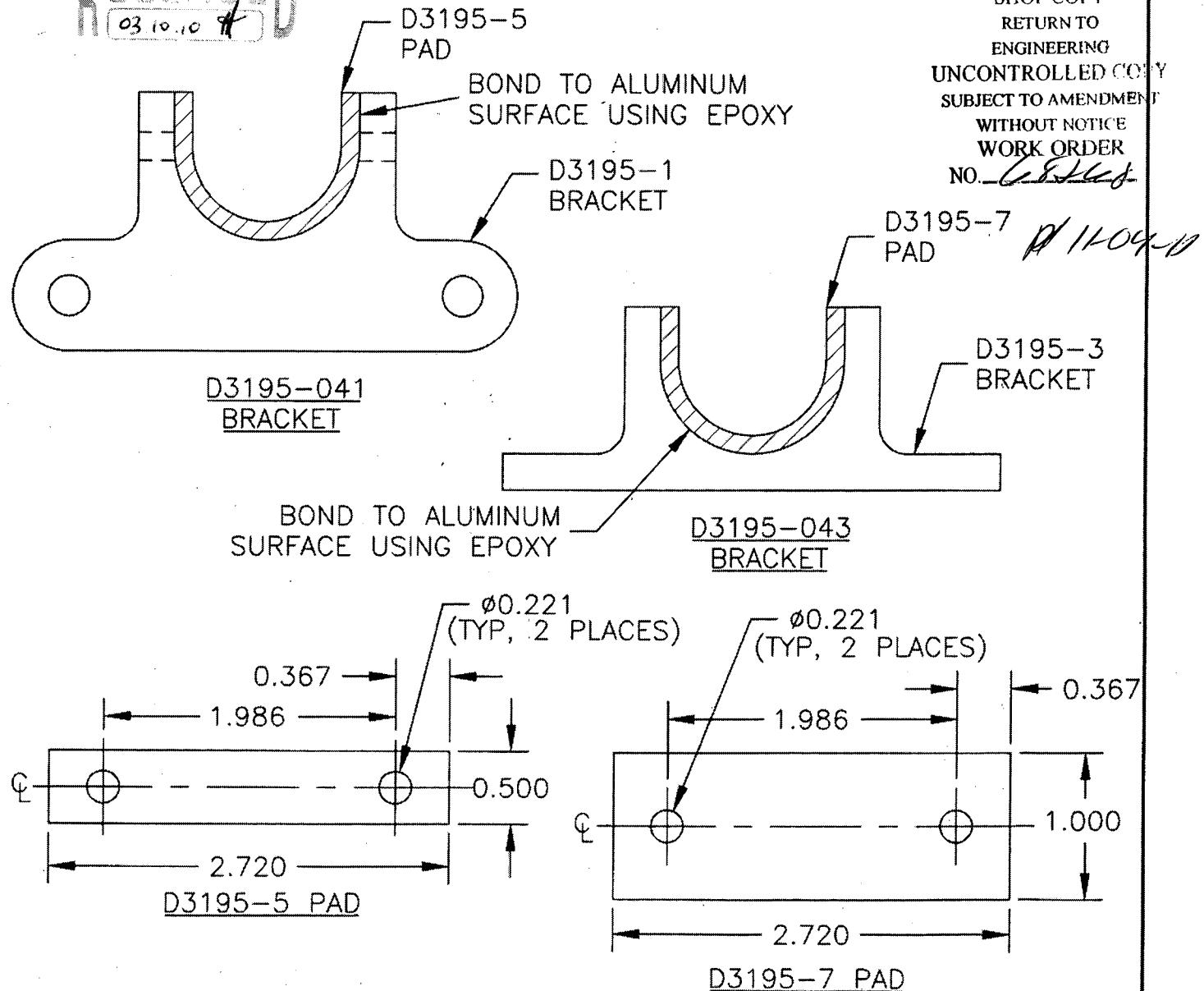
DART



DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195 REV. A SHEET 1 OF 3
DATE	03.06.23			TITLE SCALE BRACKET 1:1

RELEASED
03.10.10 #

A 03.06.23 NEW ISSUE



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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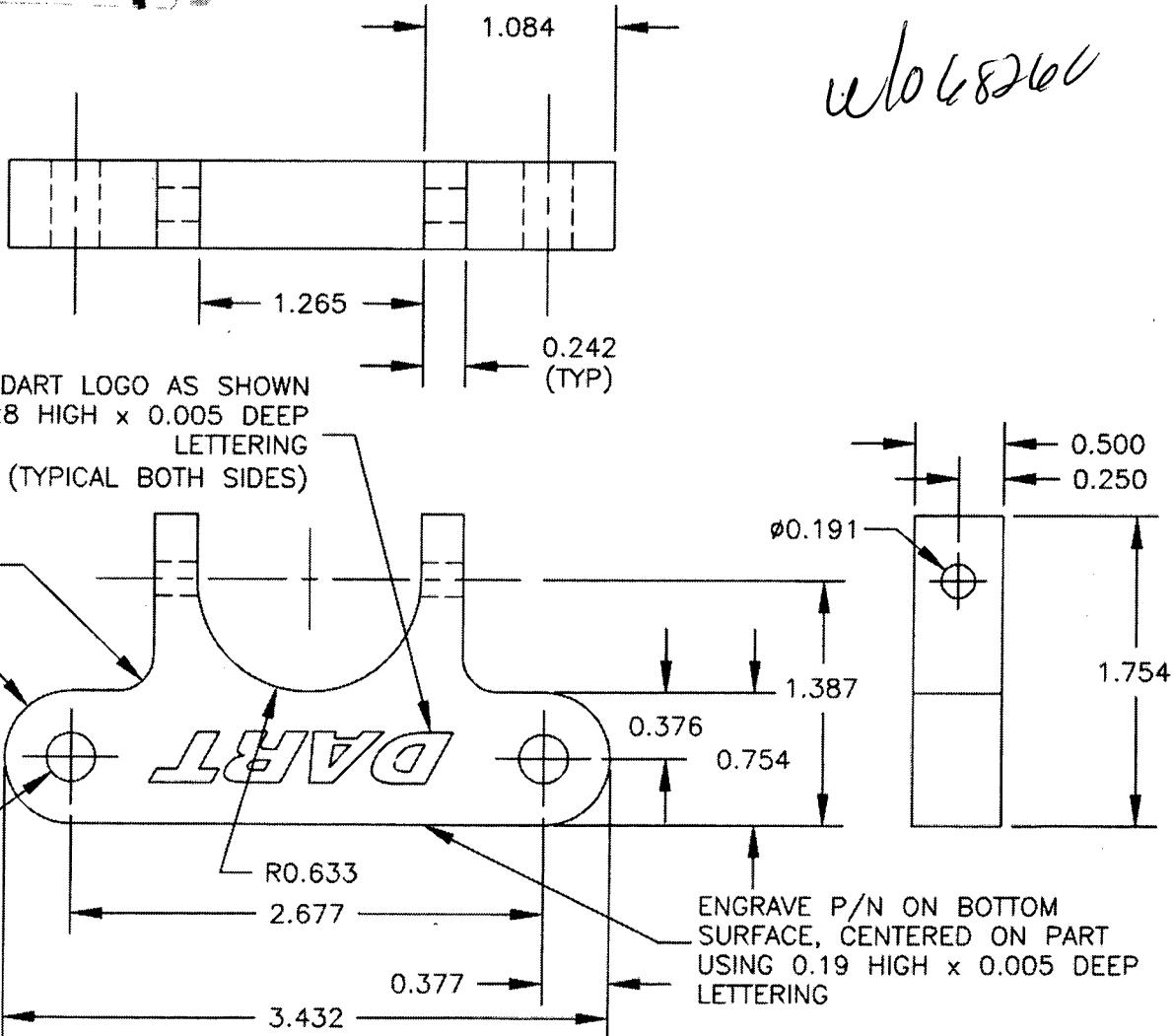
NOTE: Date & initial all entries



COPY ISSUED
NOV 2003

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3195
DATE		REV. A SHEET 2 OF 3 TITLE SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

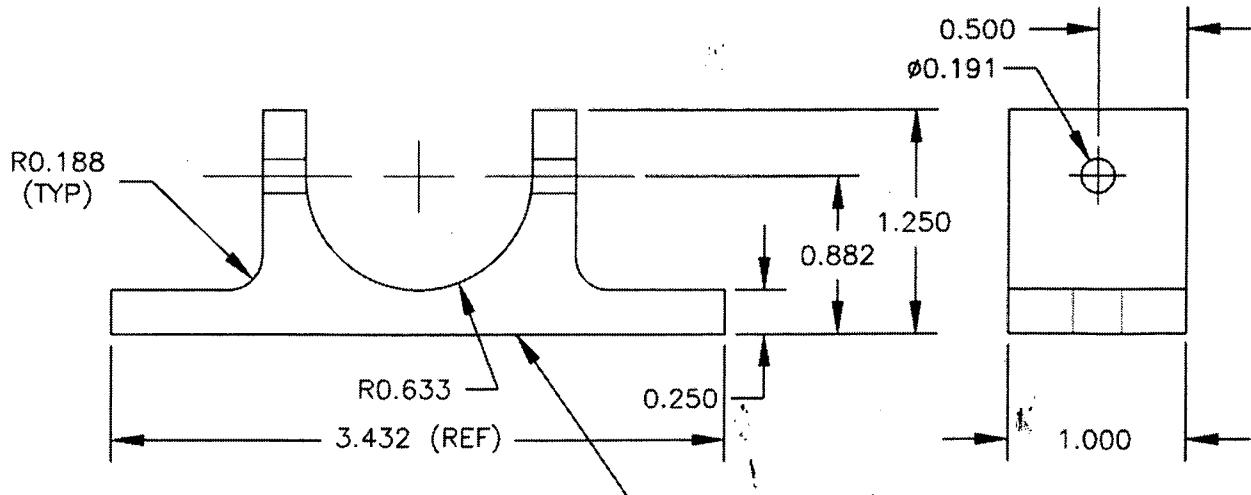
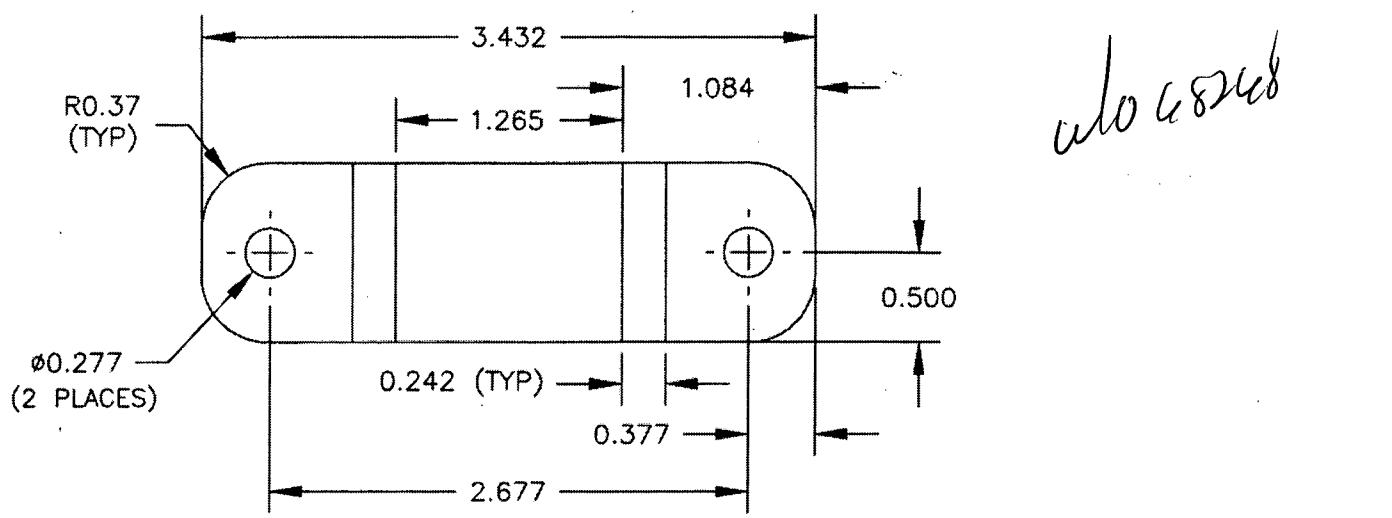
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DP	DRAWN BY	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195 REV. A SHEET 3 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE 1:1

**RELEASED**
03.06.10

ENGRAVE P/N ON BOTTOM SURFACE, CENTERED ON PART USING 0.19 HIGH X 0.005 DEEP LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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